

# Work Order ID 85617

**\*85617\***

Page 1

Item ID: D4148-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Crosstube Lug Assembly, Fwd

Start Date: 12/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/12 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4148

D

100

0.00

**\*100\***

Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

4x

9/12/06/13

110

QC5- Inspect part completeness to step on W/O

0.00

**\*110\***

QC

Memo

0.00

Quality Control

4x

12/06/13

120

Identify as per dwg & Stock Location: 8T 468 0.00

**\*120\***

Packaging

Memo

0.00

Packaging

4x

12-6-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 85617**

June-12-12 8:50:39 AM

**\*85617\***

Page 2

Item ID: D4148-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Crosstube Lug Assembly, Fwd

Start Date: 12/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

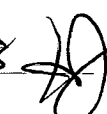
**\*130\***

QC

Memo

0.00

Quality Control

12/6/18   
MF  
12-06-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

June-12-12 8:50:43 AM

Page 1

Work Order ID: 85617

**\*85617\***

Parent Item: D4148-041

**\*D4148-041\***

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 4.00

Required Qty: 4.00

## Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

10.10.29 as per revC DD verf:EC

AS PER DWG REV.D DD VERF:EC

IPP Rev:C

IPP REV:D 11.03.02

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3 <b>*MS21043-3*</b> Nut		Purchased	No			100	Each	1,428.000	4	8			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				72					
					103691			72					
				ST301				1356					
					118077			2					
					118614			51					
					118686			30					
					119758			20					
					121255			283					
					121708			970					
MS21043-4 <b>*MS21043-4*</b> Nut		Purchased	No			100	Each	1,229.000	1	12			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				40					
					104603			40					
				ST301				1189					
					119546			131					
					121162			558					
					121652			500					

EP 12/06/13

EP 12/06/13

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 85617

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Parent Item: D4148-041

**\*D4148-041\***

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 4.00

Required Qty: 4.00

D2690-6 Manufactured No

100 Each 16.0000 1 4

**\*D2690-6\***

Lanyard Assembly

\*\*

Location

Loc Qty

Loc Code

ST014

16

83360

16

D3910-1 Manufactured No

100 Each 35.0000 1 4

**\*D3910-1\***

Crosstube Lug

\*\*

Location

Loc Qty

Loc Code

st507

35

81474

2

81573

33

D4091-1 Manufactured No

100 Each 70.0000 1 4

**\*D4091-1\***

Mounting Lug

\*\*

Location

Loc Qty

Loc Code

ST458

70

81168

26

81461

4

81575

40

D4148-1 Manufactured No

100 Each 18.0000 2 8

**\*D4148-1\***

Crosstube Lug Plate, Fwd

\*\*

Location

Loc Qty

Loc Code

ST101

18

82964

3

83421

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 85617

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

\*85617\*

\*D4148-041\*

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 4.00

Required Qty: 4.00

D4148-3 Manufactured No

100 Each 8.0000 1 4

\*D4148-3\*

Stud Receiver, Lower

\*\*

Location

Loc Qty

Loc Code

ST101

8

83356

8

D4148-5 Manufactured No

100 Each 13.0000 1 4

\*D4148-5\*

Eyebolt Stud

\*\*

Location

Loc Qty

Loc Code

ST102

13

82965

1

84196

12

AN3C12A Purchased No

100 Each 239.0000 2 8

\*AN3C12A\*

Bolts

\*\*

Location

Loc Qty

Loc Code

GA

38

120449

38

ST351

201

117514

4

118112

5

118451

22

119510

1

120423

65

121259

4

121584

50

121689

50

June-12-12 8:50:43 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

June-12-12 8:50:43 AM

Page 4

Work Order ID: 85617

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

\*85617\*

\*D4148-041\*

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 4.00

Required Qty: 4.00

AN4C13A Purchased No

100 Each 60.0000 3 12

\*AN4C13A\*

BOLT

\*\*

Location

Loc Qty

Loc Code

ST357

60

120187

1

121556

9

121827

50

MS17984-C413

Purchased No

100 Each 23.0000 1 4

\*MS17984-C413\*

PIN, QUICK RELEASE

\*\*

Location

Loc Qty

Loc Code

ST315

3

114340

1

118612

2

ST333

20

121350

20

MS20615-4M18

Purchased No

100 Each 85.0000 8 32

\*MS20615-4M18\*

Rivet

\*\*

Location

Loc Qty

Loc Code

322

35

121349

35

ST322

50

121444

50

NAS1149C0332R

Purchased No

100 Each 186.0000 4 16

\*NAS1149C0332R\*

Washer

\*\*

Location

Loc Qty

Loc Code

ST298

186

121509

186

June-12-12 8:50:43 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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June-12-12 8:50:43 AM

Page 5

Work Order ID: 85617

\*85617\*

Parent Item: D4148-041

\*D4148-041\*

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0432R

Purchased

No

100

Each

3,866.000

6

24

**\*NAS1149C0432R\***

\*\*

Washer

Location

Loc Qty

Loc Code

ST297

1102

117291

102

119124

1000

ST298

2764

121255

2764

*LB 12/06/13*

*24*

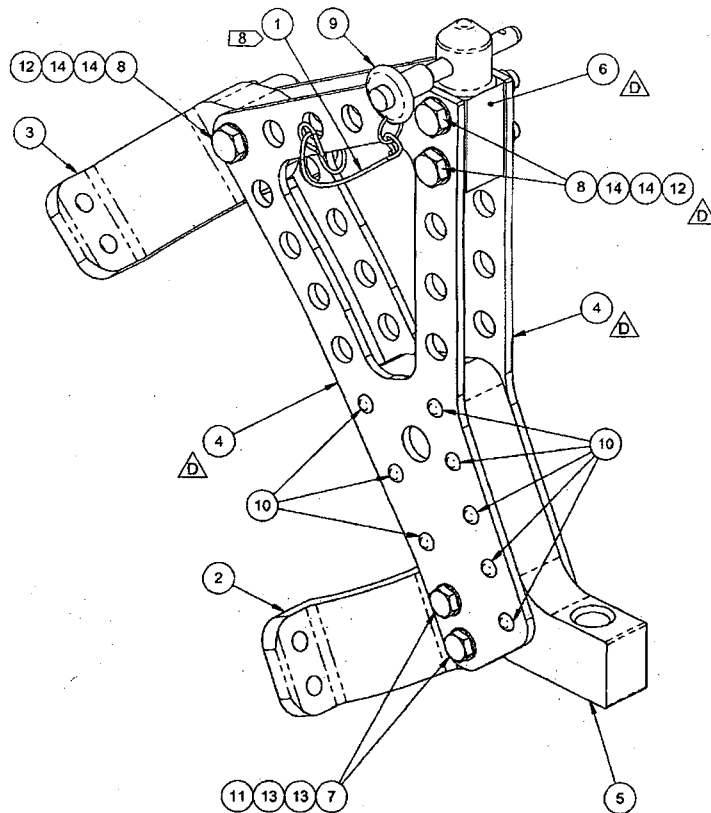
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4148-041 FWD X-TUBE LUG ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
- 7) WEIGHT: 3.67 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85617 MLC  
12/06/12

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	2	MS21043C3	NUT
12	3	MS21043C4	NUT
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER

**RELEASED**  
2011-02-24

D	HOLE DIA CHANGED TO 0.252" (D6-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, C4-2)	SC	11.02.22
C	REDESIGNED D4148-1/3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS 0.129 (ZN C8-5) REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

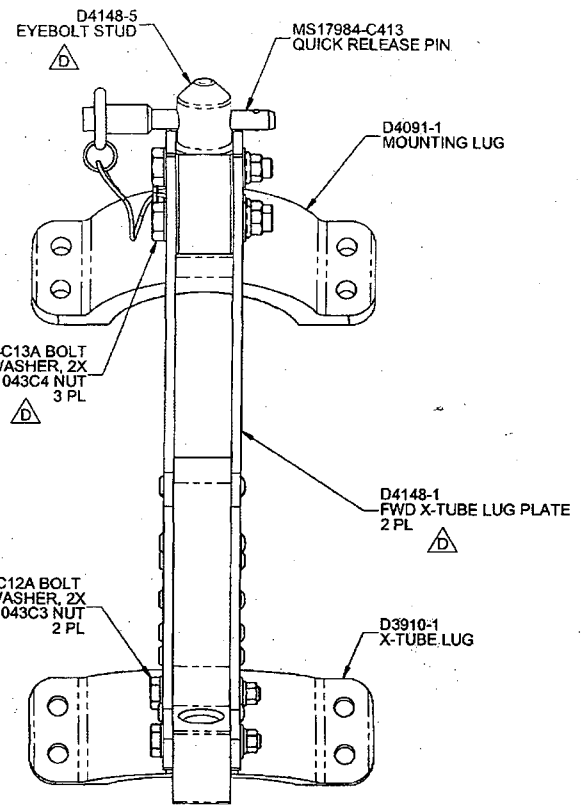
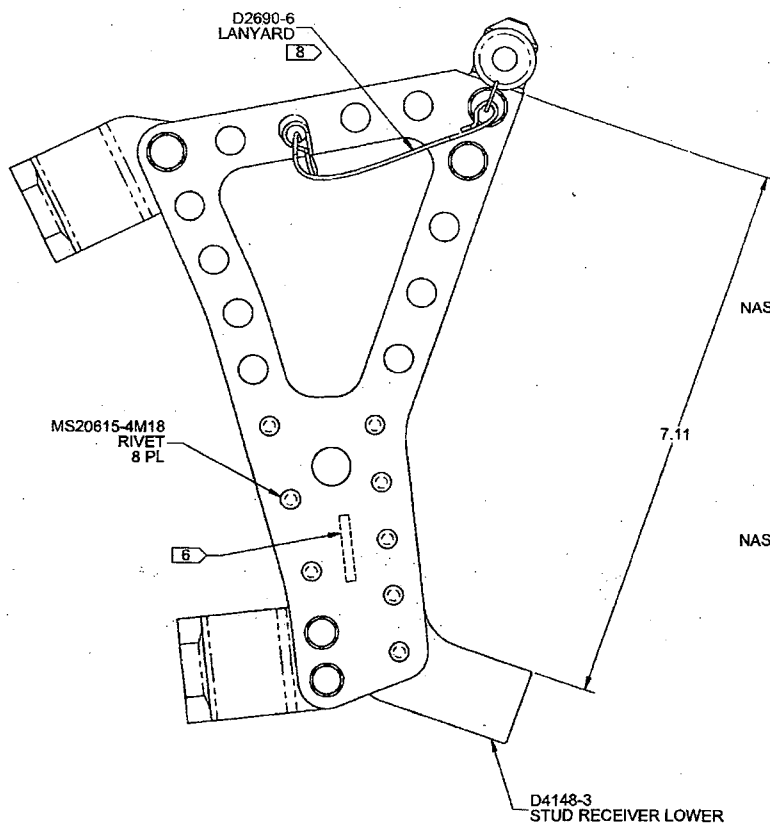
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





25617

**D4148-041 FWD X-TUBE LUG ASSY**

**RELEASED**  
2011-02-24  
JMI

DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	5	DRAWING NO. <b>D4148</b>	REV. D
MFG. APPR.		SHEET 2 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		<b>FWD X-TUBE LUG ASSY</b>	NTS
DATE	11.02.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ON ANY EQUIPMENT TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

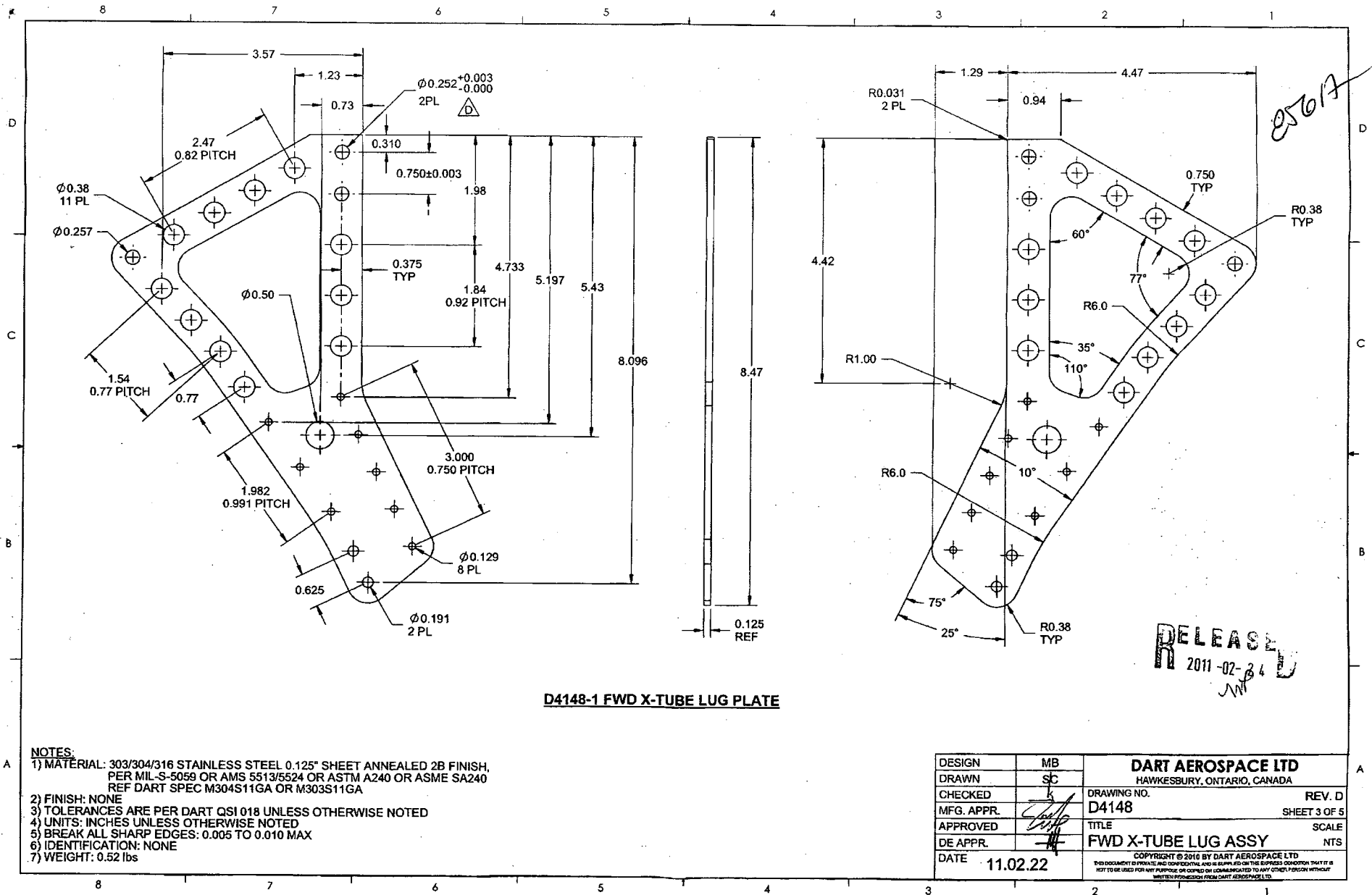
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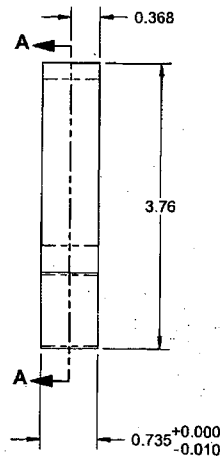
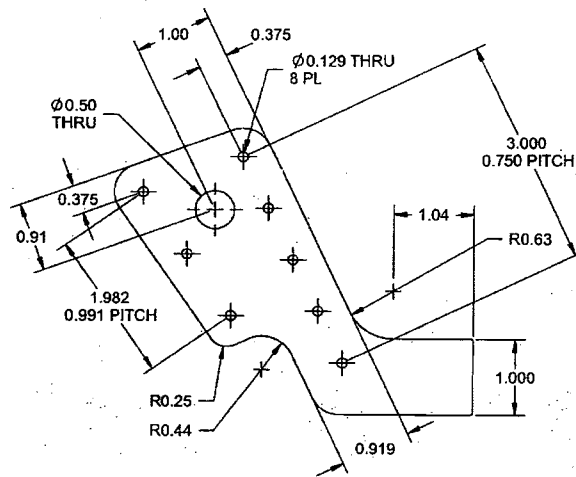
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

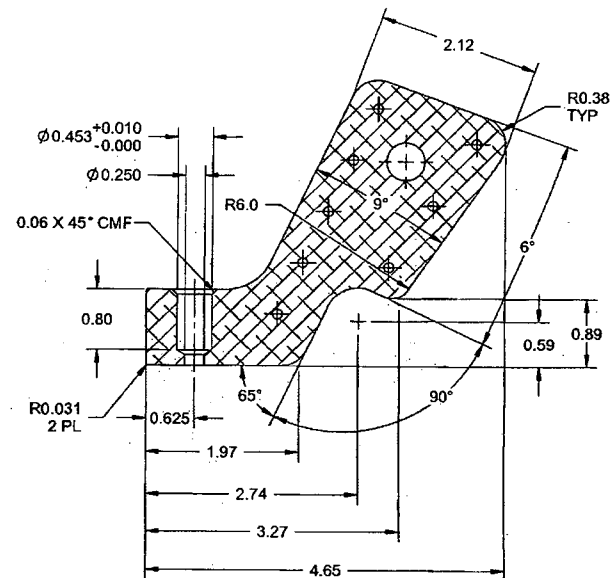
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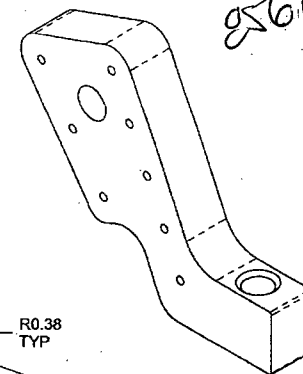
**NOTE:** Date & initial all entries



**D4148-3 STUD RECEIVER LOWER**



**SECTION A-A**



**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276  
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.52 lbs

DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO. <b>D4148</b>	REV. D
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>FWD X-TUBE LUG ASSY</b>	NTS
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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2011-02-24

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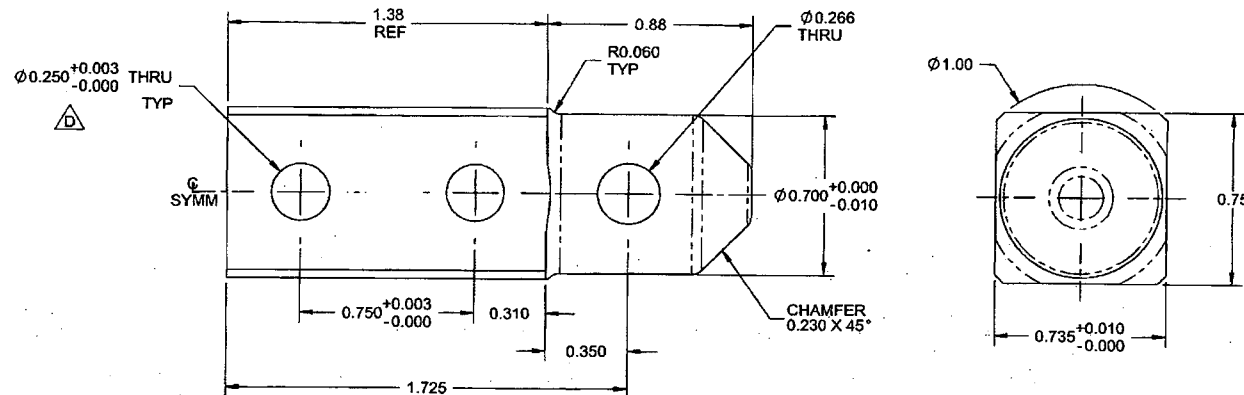
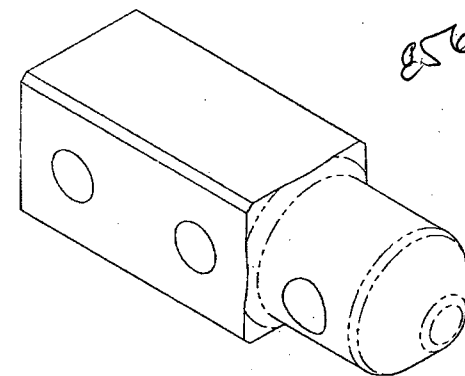
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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856 17






**D4148-5 EYEBOLT STUD**

**RELEASED**  
2011-02-22

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276  
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs

DESIGN	MB	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		<b>D4148</b>	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>FWD X-TUBE LUG ASSY</b>	NTS
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries